

Date: Monday, 28/08/2006 8:51:55 AM  
User: Linda Lacelle

# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : PLUG
<b>Job Number</b> : 28347	
<b>Estimate Number</b> : 12322	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D3492041
<b>This Issue</b> : 28/08/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3492 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 27518	<b>Material</b> : N/A
<b>Written By</b> : _____	<b>Due Date</b> : 04/09/2006
<b>Checked &amp; Approved By</b> : _____	<b>Qty:</b> 10 <b>Um:</b> Each
<b>Comment</b> : est rev A 06.03.03 New Issue EC Est Rev:B 06-08-28 As per Rev B JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6R0625	6061-T6 Round Bar .625"
<b>Comment:</b> Qty.: 0.0656 f(s)/Unit Total : 0.5250 f(s) 6061-T6 Round Bar .625" (M6061T6R0625) Batch: M101421 <i>AS</i> 06/08/28		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
<b>Comment:</b> HARDINGE CNC LATHE SMALL  1-Turn as per Folio FA633 & Dwg D3492 Dwg Rev: B Folio Rev: AA <i>AS</i> 06/08/28 10		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE <i>AS</i> 06/08/28 10		
4.0	QC8	SECOND CHECK
<b>Comment:</b> SECOND CHECK <i>J.G</i> 06/08/28 10		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
<b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1  1-Deburr <i>AS</i> 06/08/28 10		

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: PLUG

Job Number: 28347

Part Number: D3492041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DL 06/08/29 (10)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3  
(Flat End Only)

a.m 06-08-29 (10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

///

06 08 29

(10)

9.0

NAS1611010

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Qty Part Number Description Batch

1 NAS1611-010 O-RING MB 101649

a.m 06-08-29 (10)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Hand Finishing

2-Assemble O'Ring as per Dwg D3492 Applying some O'Ring Lube  
A/R 55-O'Ring Lube Batch: m 101223

a.m 06-08-29 (10)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

///

06 08 29

(10)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LP Date: 06/08/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Part Number: D3492041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

*Signature* 02/08/09

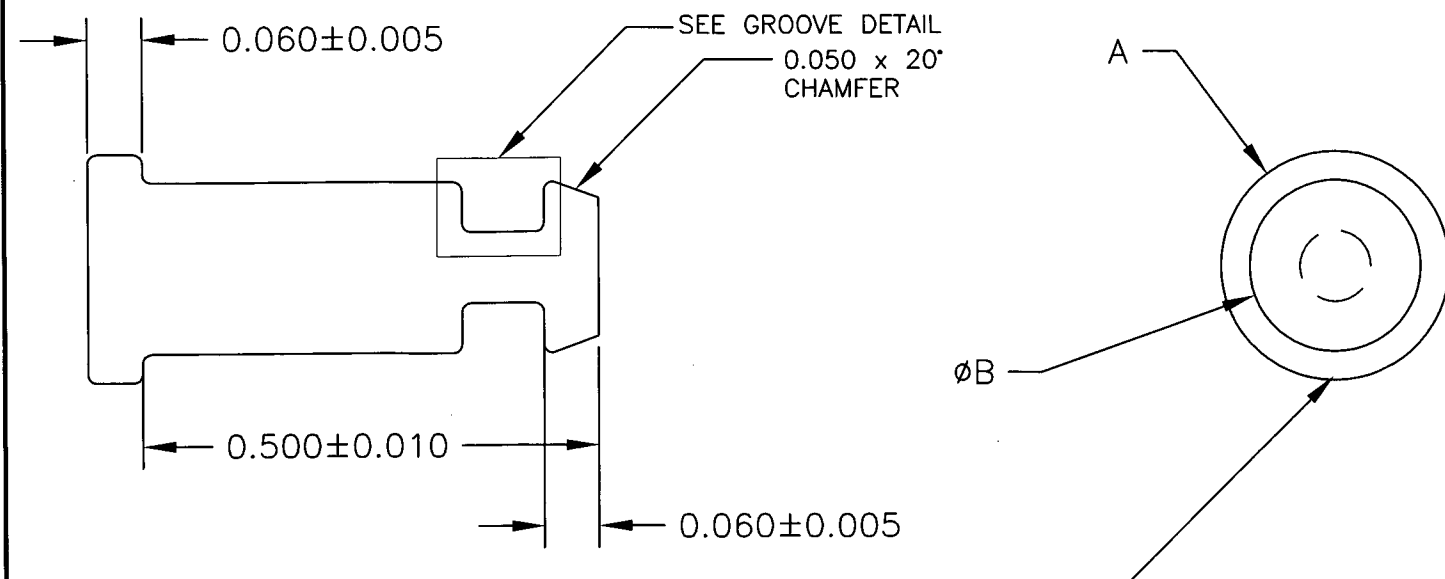
Job Completion



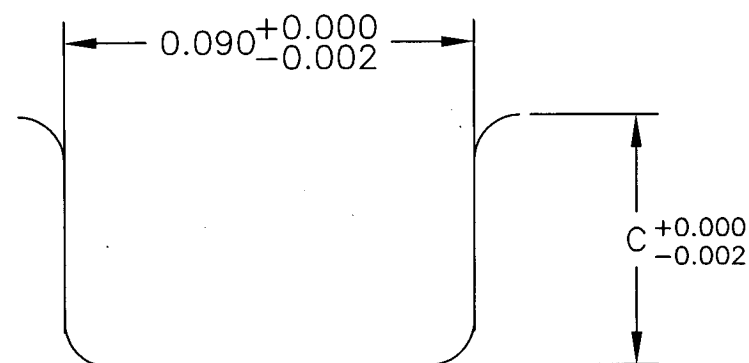
*CY00002129*

*Dates*

*Please return  
to PH*



D3492-1/-3/-5/-7 PLUGS IN ACCORDANCE WITH TABLE 1



GROOVE DETAIL

TABLE 1 D3492-1/-3/-5/-7 PLUG DIMENSIONS

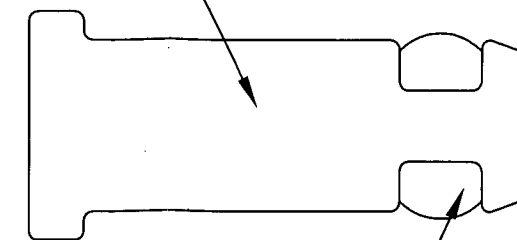
P/N	A	B	C	MATERIAL SPEC
D3492-1 ✓	0.625	0.394	0.055	M6061T6R0.625
D3492-3 ✓	0.750	0.582	0.045	M6061T6R0.750
D3492-5 ✓	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500



**D3492-1/-3/-5/-7 PLUG NOTES**

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6RD.DDD)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTE
- 5) BREAK ALL SHARP CORNERS 0.010 MAX

D3492-1/-3/-5/-7 PLUG IN ACCORDANCE WITH TABLE 2



NAS1611-005/-007/-010/-013 O-RING IN ACCORDANCE WITH TABLE 2

**D3492-041/-043/-045 PLUG** JUN,

Re: the e-mail I sent about D3492-041 plug

We will need at least (8)

**PRELIMINARY ISSUE**

D3492-041/-043/-045 PLUG ASSEMBLY PARTS  
(TABLE 2)

Qty -041	Qty -043	Qty -045	Qty -047	Part Number	
X				D3492-041	PLUG AS
	X			D3492-043	PLUG AS
		X		D3492-045	PLUG ASSEMBLY
			X	D3492-047	PLUG ASSEMBLY
1				D3492-1	PLUG
	1			D3492-3	PLUG
		1		D3492-5	PLUG
			1	D3492-7	PLUG
		1		NAS1611-005	O-RING
			1	NAS1611-007	O-RING
1				NAS1611-010	O-RING
	1			NAS1611-013	O-RING



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B	06.05.11	ADD -047; UPDATE DIM A, -045
A	06.01.04	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3492
DATE	06.05.11	TITLE PLUG
		REV. B SHEET 1 OF 1 SCALE NTS







1760617620605  
m 101421

KAISER ALUMINUM  
ENGINEERED PRODUCTS  
1700 SOUTH HARLEM AVE  
BRIDGEVIEW IL 60455

KAISER ALUMINUM  
MATERIAL CERTIFICATION  
COPPER & BRASS SALES  
6905 KENDERRY GATE UNIT 4  
MISSISSAUGA, ON L5T2Y8

PAGE 1

COPPER & BRASS SALES

SOUTHFIELD MI 48086 CH7472

11/15/05

SOLD TO PURCHASE ORDER

DATE PRINTED

018508-2/STK 0.625 PRECIS ROD +/- .004 TOL

CUSTOMER PART NUMBER DESCRIPTION

974832-001  
RELEASE-ITEM

562 083  
LOT

6061-T6511B  
ALLOY/TEMPER

MECHANICAL PROPERTY RESULTS

REFERENCE	SAMPLE#	UTS (KSI)	YTS (KSI)	%Elong in 2"	HARDNESS	CONDUCT.	BEND
TR038098	0001 0001	54.2	51.3	12.8		N/A	N/A
TR038098	0001 0002	53.4	50.7	12.5		N/A	N/A
TR038098	0001 0003	54.4	51.8	12.6		N/A	N/A
TR038098	0001 0004	54.3	51.1	12.6		N/A	N/A
TR038098	0001 0005	53.9	51.3	12.5		N/A	N/A
TR038098	0001 0006	52.4	49.5	12.5		N/A	N/A
TR038098	0001 0007	54.2	51.3	12.5		N/A	N/A

CHEMICAL COMPOSITION (WT%), ALUMINUM REMAINDER

5061 LIMITS	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Bi	Zr	Ea	Tot	Others
Maximum	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	NA	NA	NA	0.05	0.15	
Minimum	0.40		0.15		0.8	0.04			NA	NA	NA			

APPLICABLE REQUIREMENTS:

PER ASTM-B221-02, \*NO STENCIL\*  
ASME-SB221 1998 SECT II  
PER AMS-QQ-A-200/8  
MS#6061  
MEETS ALL SPECIFICATION  
REQUIREMENTS FOR 6061-T6511  
ELEVATED MINIMUM MECHANICAL  
PROPERTIES AS FOLLOWS:  
TS = 42.0 KSI MIN  
IELD = 38.0 KSI MIN  
ELONGATION = 10.0% MIN

Kaiser Aluminum & Chemical Corp. ('Kaiser')  
hereby certifies that metal shipped under  
this order has been inspected and tested  
and found in conformance with the applicable  
specifications forming a part of the descrip-  
tion set forth in Kaiser's sales acknowledge-  
ment form. Any warranty is limited to that  
shown on Kaiser's general terms & conditions  
of sale. Test reports are on file, subject  
to examination.

Frank E. Watson  
Quality Assurance Manager